

Work Order ID 80479

\*80479\*

Page 1

February-21-12 1:49:05 PM

Item ID: D3570-2 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Bracket

Start Date: 21/02/2012 Start Qty: 6.00 \*6\* Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00 \*6\* Customer:

Reference:

Approvals: Process Plan: M.C.J. Date: 24/02/12 Tooling: Date: Run Start \*NR1\*

QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3570	Rev E								

100 0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

B12-3-8

FLOW CNC Waterjet

1-Cut as per Dwg D3570

6061 . 125

Dwg Rev: E

Prog Rev: E

\*\*\*GRAIN DIRECTION AS PER DWG\*\*\*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

B12-3-8

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80479

February-21-12 1:49:05 PM

**\*80479\***

Page 2

Item ID: D3570-2

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 21/02/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

8.263/08

(x8)

Quality Control

130

Small Fab

0.00

**\*130\***

Small Fab

Memo

0.00

1-Form as per Dwg D3570 Using DT8945

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

8

φ

12/04/12  
FF

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

8.264/12

(x8)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Required Date: 06/03/2012 Req'd Qty: 6.00 \*6\* Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
*150*									
HandFinish	Memo	0.00				8X	✓		M-L 12/04/14
Hand Finishing									
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
*160*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:30 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:00					8X	✓		M-L 12/04/14
170	QC3- Inspect Part Finish	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

M 117338

⑧

M-L  
12/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 80479**

February-21-12 1:49:05 PM

**\*80479\***

Page 4

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*180\***

Packaging

Memo

0.00

Packaging

190	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*190\***

QC

Memo

0.00

Quality Control

80

12/16/16 SP

12/14/17

UME

12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

February-21-12 1:49:09 PM

Page 1

Work Order ID: 80479

\*80479\*

Parent Item: D3570-2

\*D3570-2\*

Parent Item Name: Bracket

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03.26 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	105.9400	0.07	0.442105			

\*M6061T6S 125\*

\*\*

B12-3-8

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT021

105.94

113608

53.85

118217

4.99

119513

10.8

120218

36.3

120219

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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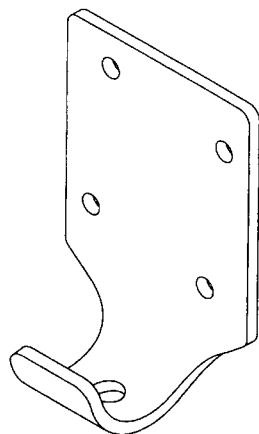
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

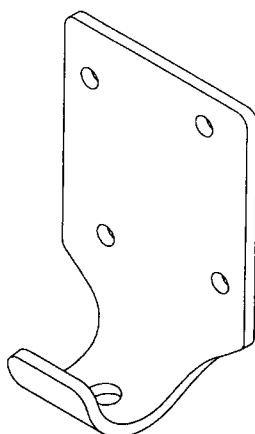
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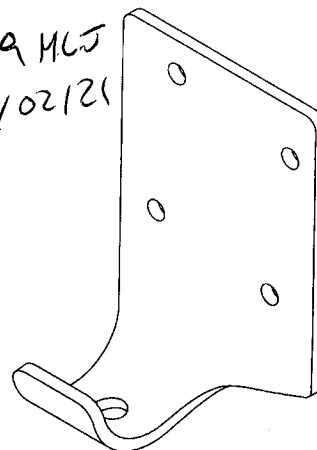
**NOTE:** Date & initial all entries



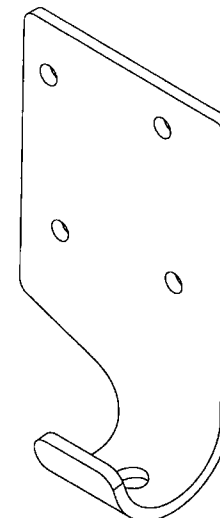
**D3570-1 BRACKET**



**D3570-2 BRACKET**



**D3570-3 BRACKET**



**D3570-4 BRACKET**

**RELEASED**  
09/04/22

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.04.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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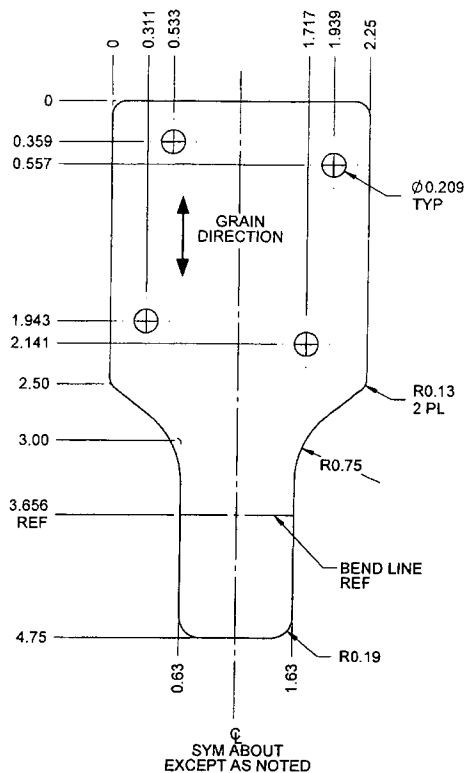
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

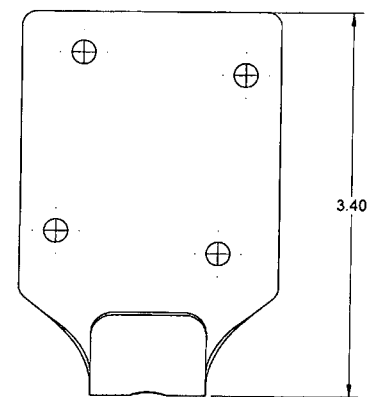
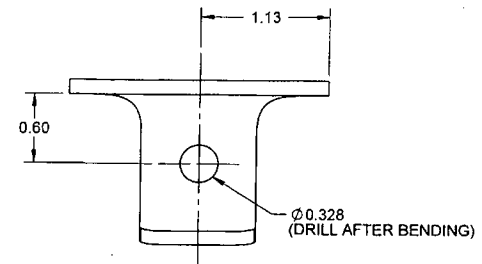
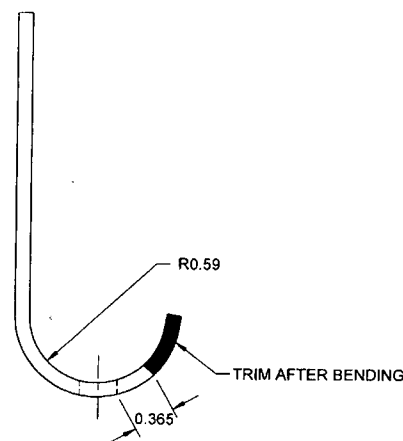
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8047A



**D3570-1F FLAT PATTERN**



**D3570-1 BRACKET**  
(MAKE FOM D3570-1F)

**RELEASED**  
29/6/13 NP

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3570</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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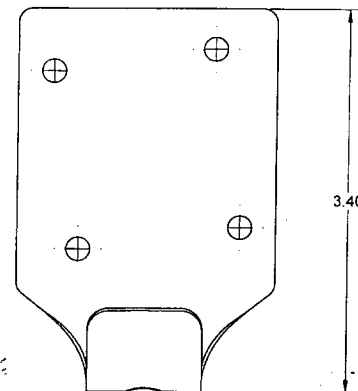
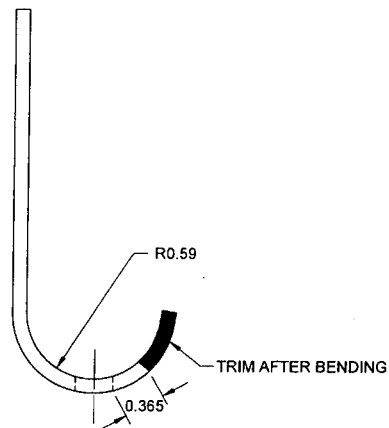
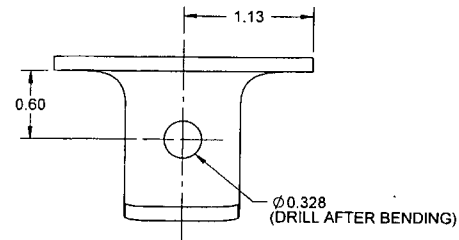
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**NOTE:** Date & initial all entries



80479



**D3570-2 BRACKET**  
(MAKE FROM D3570-TF)

**RELEASED**  
09/24/23 M4

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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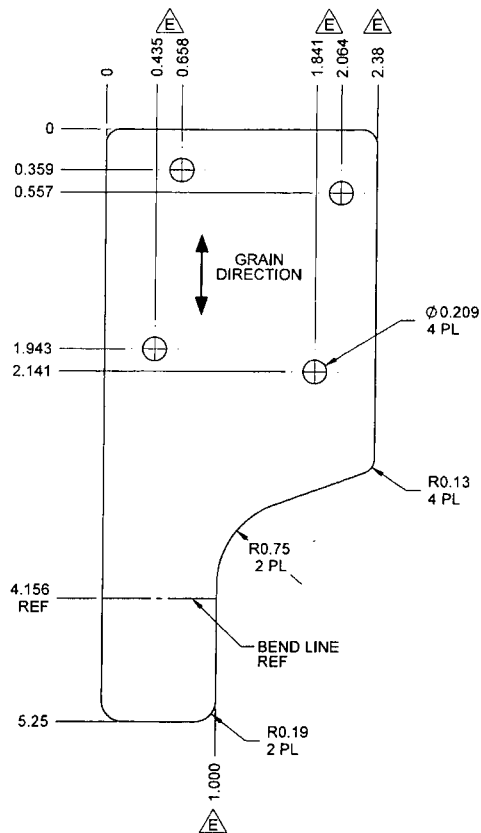
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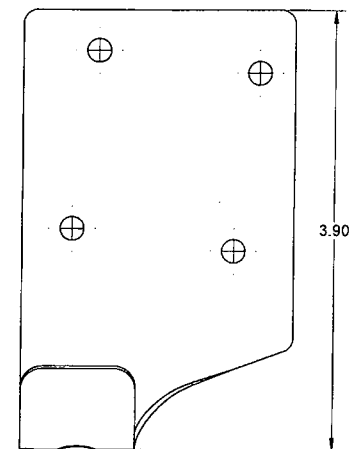
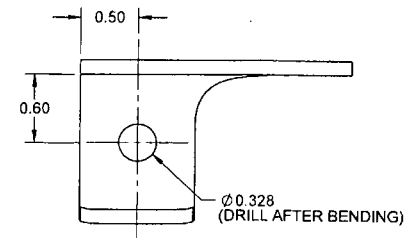
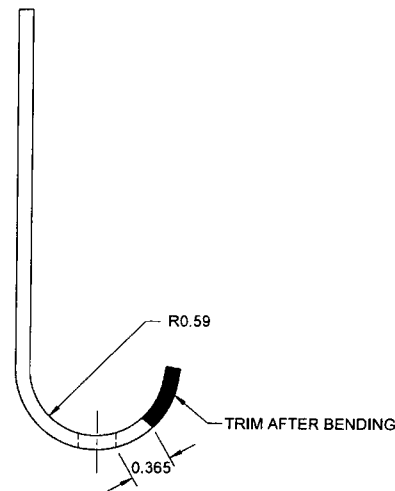
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60479



**D3570-3F FLAT PATTERN**



**D3570-3 BRACKET**  
(MAKE FROM D3570-3F)

**RELEASED**  
07/24/23 MD

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3570</b>	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE <b>BRACKET</b>	SCALE NTS
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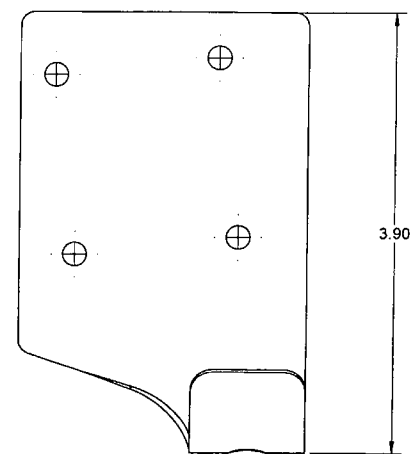
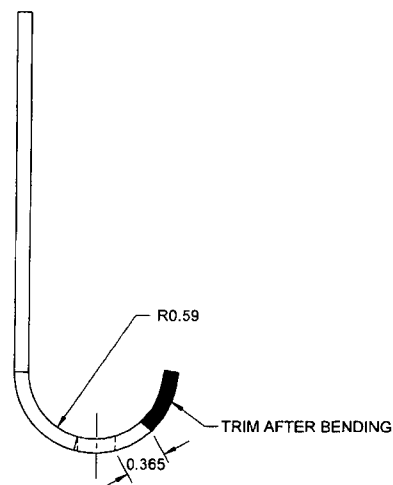
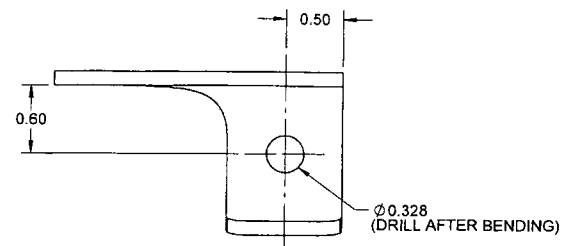
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3570-4 BRACKET**  
(MAKE FROM D3570-3F)

**RELEASED**

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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